

Work Order ID 117460

117460

Page 1

April-24-14 11:31:41 AM

Item ID: D412-709-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Panel Door Modification Clear Fits LH or RH

Start Date: 4/24/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 140430

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-709 bluefile & type labels per PPP D412-709-015 CHG002

DAS
38
9-89

1

2

24

14/08/28

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

DAS
28
9-89

1X

JUN 20 2014

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

1

2

24

14/08/29

DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width:33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width:33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width:33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 117460***117460***

Page 2

April-24-14 11:31:41 AM

Item ID: D412-709-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge Panel Door Modification Clear Fits LH or RH

Start Date: 4/24/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/24/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-015								
	Location: <u>017</u>								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

AUG 28 2013

DAS
06
9-89

ML5 14-08-29

ML5 14-08-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Picklist Print

April-24-14 11:31:40 AM

Page 1

Work Order ID: 117460

117460

Parent Item: D412-709-015

D412-709-015

Parent Item Name: Hinge Panel Door Modification Clear Fits LH or RH

Start Date: 4/24/14

Required Date: 4/24/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. B 05.03.08 D3240-1 no longer made in house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126 *D2126* Seal		Manufactured	No			110	f	404.6800	62	7		DAS 28 9-89	JUN 20, 2014
cut(1) at 72" 00 EB 14/6/20													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST405			0.68						
					102729		0.68						
				ST406			404						
					<u>110653</u>		404						
D3236-1 *D3236-1* Window		Manufactured	No			110	Each	3.0000	1	1		DAS 28 9-89	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST217			3						
					105292		3						
D3240-1 *D3240-1* Frame		Manufactured	No			110	Each	5.0000	1	1		DAS 28 9-89	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST215			5						
					<u>105344</u>		4						
					86780		1						

DQA: _____ Date: _____



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